

Work Order ID 82325

82325

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Item ID: D2327-3 Accept ***N900040100*** Setup Start ***NS1***
 Revision ID: Stop ***NS2***
 Item Name: Spacer Bushing
 Start Date: 28/03/2012 Start Qty: 40.00 ***40*** Cust Item ID:
 Required Date: 11/04/2012 Req'd Qty: 40.00 ***40*** Customer:
 Reference:

Approvals: Process Plan: MLJ Date: 12/03/28 Tooling: _____ Date: _____ Run Start ***NR1***
 QC: _____ Date: _____ SPC (Y/N): _____ Date: _____ Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
Draw Nbr	Revision Nbr								
D2327	Rev D								

100 Hardinge CNC LATHE SMALL 0.00
100
 Hardinge Memo 0.00 SL 12-05-31 (40)
 Hardinge CNC Lathe Small Turn per Folio FA232 and Dwg D2327 Debur

110 QC2- Inspect parts off machine FAI/FAIB 0.00
110
 QC Memo 0.00 SL 12-05-31 (40)
 Quality Control

120 QC8- Inspect parts - second check 0.00
120
 QC Memo 0.00 ant 12/05/31 40
 Quality Control

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

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Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
130	Identify as per dwg & Stock Location: <u>WA</u>	0.00							
130									
Packaging	Memo	0.00							
Packaging	*****STOCK IN BASKET CELL*****								
140	QC21- Final Inspection - Work Order Release	0.00							
140									
QC	Memo	0.00							
Quality Control									

Pl 12-05-31 *40* *[Signature]*

12/6/4 *[Signature]*

mf
12-05-31

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Picklist Print

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Work Order ID: 82325

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Parent Item: D2327-3

D2327-3

Parent Item Name: Spacer Bushing

Start Date: 28/03/2012

Required Date: 11/04/2012

Start Qty: 40.00

Required Qty: 40.00

Comments: IPP F05.11.02Removed 303 SSKJ/EC

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
M304R0.375		Purchased	No			100	f	13.7510	0.1563	6.581053			

M304R0 375

304 ROUND BAR 0.375

**

SL 12-05-31

Location

Loc Qty

Loc Code

MAT029

13.751

119346

1.564

120204

12.187

121380

6.6

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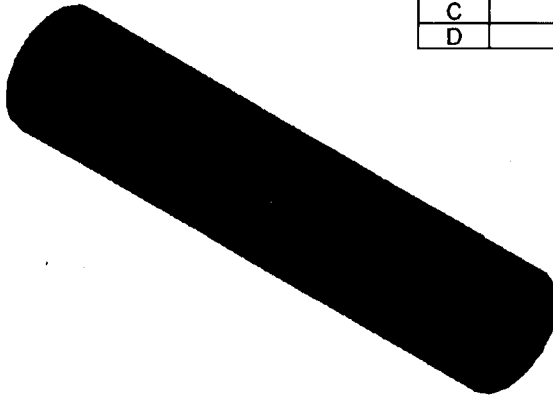
Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

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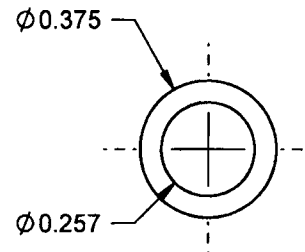
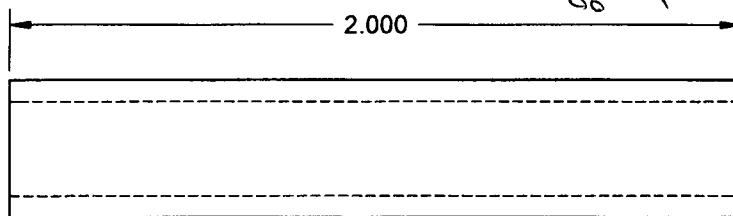
DESIGN BW	DRAWN BY CB	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED LE	APPROVED JH	DRAWING NO. D2327	REV. D SHEET 1 OF 1
DATE 06.10.12	TITLE SPACER BUSHING		SCALE 2:1
REV	DATE	DESCRIPTION	
A	94.12.17	NEW ISSUE	
B	95.12.06	LENGTH CHANGE	
C	03.05.13	303 SS SPEC ADDED	
D	06.10.12	REMOVE 303 SS MATERIAL	



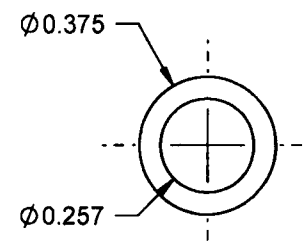
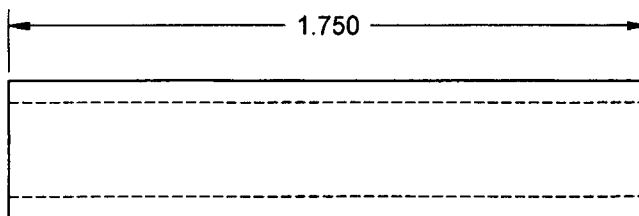
NO. 02327
12/03/20
WORK ORDER
WITHOUT NOTICE
SUBJECT TO AMENDMENT
UNCONTROLLED COPY
ENGINEERING
RETURN TO
SHOP COPY

RELEASED

06.11.14



D2327-1 SPACER BUSHING



D2327-3 SPACER BUSHING

NOTES:

- 1) MATERIAL: AISI 304/316 SS, Ø0.375, 0.065 WALL SEAMLESS ROUND TUBING
(REF. DART SPEC M304TR0.375W.065)
- 2) FINISH: NONE
- 3) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) ALL DIMENSIONS ARE IN INCHES UNLESS OTHERWISE NOTED
- 5) BREAK ALL SHARP CORNERS TO 0.010 MAX



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